

Date: Monday, 1/7/2008 11:33:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BAFFLE ASSEMBLY
Job Number : 36597	
Estimate Number : 11265	
P.O. Number :	Part Number : D3276042
This Issue : 1/7/2008 S.O. No. :	Drawing Number : D3276 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 36503	Material :
Written By :	Due Date : 1/30/2008 Qty: 12 Um: Each
Checked & Approved By : <u>[Signature] 08.01.07</u>	
Comment : Est Rev:A New Issue 05-12-06 JLM	
Est Rev:B Now on Waterjet 06-09-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 1.0715 sf(s)/Unit Total : 12.8583 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.040" thick
 (M6061T6S.040)
 Batch: 106747 IB 8-1-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3276
 Dwg Rev: B IB 8-1-9
 Prog Rev: B

(12)

2-Deburr if necessary IB 8-1-9

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-1-9

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/01/10 (412)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3276

SP 08/01/15 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276

SB 08/01/15 (12)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/01/15 (12)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-01-16

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 08/01/17 (12)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-01-07

11.0

D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total: 27.0000 f(s)

Pick:

Qty Part Number

Description Batch

27.0" D2464

Neoprene Seal

35433

AS 08/01/18 (12)

12.0

D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3276-3

Decal

36663

AS 08/01/18 (12)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3276

SB 08/01/22 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 08/01/22 (X12)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 179

AS 08/01/22 (X12)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.23 AS

Job Completion



Kim 2008/1/23
W

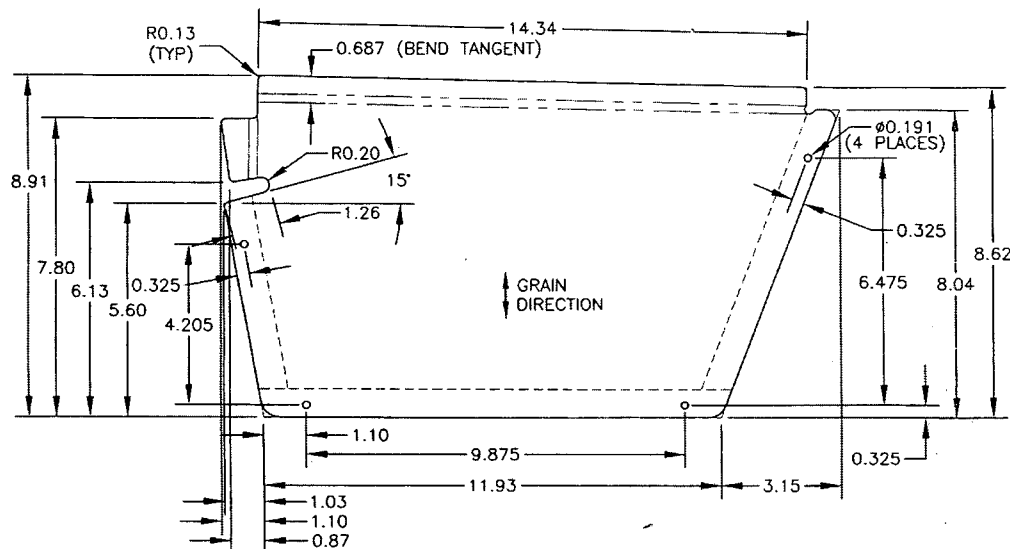
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

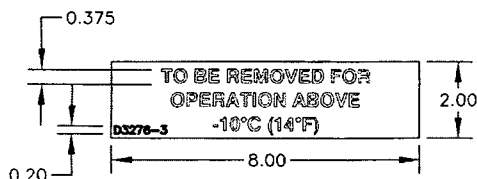
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



D3276-1 BAFFLE (FLAT PATTERN)

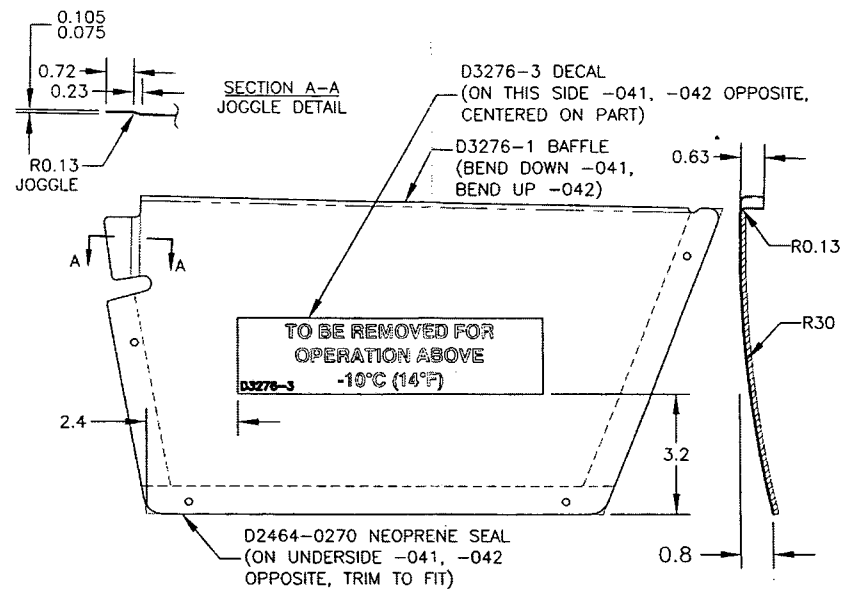
- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36597



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)

D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

RELEASED
05-01-07

B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DRAWN BY
CHECKED	CP	APPROVED
DATE	05.01.25	TITLE
		BAFFLE ASSEMBLY
		SCALE
		1:3

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DART DART AEROSPACE LTD.
MARKHAM, ONTARIO, CANADA

DRAWING NO. D3276
REV. B
SHEET 1 OF 1
SCALE